

Date: Monday, 04/05/2009 1:44:47 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : REAR OVERHEAD R/H
<b>Job Number</b> : 47670B	
<b>Estimate Number</b> : 13590	
<b>P.O. Number</b> :	<b>Part Number</b> : D38232 <i>GY</i>
<b>This Issue</b> : 04/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3823-2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 47312B	<b>Material</b> : MKYD6185S080P362015
<b>Written By</b> :	<b>Due Date</b> : 11/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>JL 09 05 04</i>	<i>29</i>
<b>Comment</b> : Est. A New Issue 08/09/17 DL Rev B Dwg. Update. 09/02/09 DL verified by:DD	

POSITIVE  
RECALL

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
	<i>MD 09/05/25</i>	
	<i>M111807</i>	
<b>Comment:</b> Qty.: 11.3747 sf(s)/Unit Total: 11.3747 sf(s) 6185 Kydex .080"		



2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

*BB 09/05/21*

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

*BB 09/05/21 (X2)*

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-2 and folio FTA 031 using tool DT 9113

Dwg. Rev. *BB*  
 Folio Rev. *BB*

*BB 09/05/21 (X2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:44:47 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD R/H

Job Number: 47670B

Part Number: D38232

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 x2

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09.05.21 (x2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09.05.21 (x2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09.05.21

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090525

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP47670

POSITIVE RECALL

EFFECTIVE

RELEASE

AUTH

DATE

09/05/26

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order: 47670 B
Description:	Part Number: D3823-2
Inspection Dwg: D3823-3 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____" N/A				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JSB

Date: 09/05/21

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.44"	MIN	0.60	✓			
1.75"	MIN	1.875	✓			
0.50	MIN	0.60	✓			
0.045"	MIN	0.63	✓			
0.055"	MIN	0.77	✓			

Measured by: WJ

Date: 09/05/21

Audited by: [Signature]

Date: 09/05/22

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	













